

Date: Wednesday, 23/08/2006 11:44:05 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 28259		Part Number	: D2884		
Estimate Number	: 11055		Drawing Number	: D2884 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 23/08/2006	S.O. No.	: N/A		Drawing Revision	: B
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 21/08/2006	Type	: MACHINED PARTS		Due Date	: 28/08/2006
Previous Run	: 25982		Qty:	40	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est A 99.10.12 New Issue EC					
	Est Rev:B Now 6061-T6 06-06-23 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet 
	Comment: Qty.: 0.0663 sf(s)/Unit Total: 2.6502 sf(s) Material: 6061-T6 0.080" Thick Batch M101178	 SAP 06:08:23
2.0	WATER JET	FLOW WATER JET 
	Comment: FLOW WATER JET	SAP 06:08:23 
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAP 06:08:23 
4.0	QC8	SECOND CHECK 
	Comment: SECOND CHECK	 SFC 06-09-06 
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	 a.M 06-09-06 
6.0	QCS QC3	INSPECT WORK TO CURRENT STEP 
	Comment: INSPECT WORK TO CURRENT STEP INSPECT POWER COAT / CHEMICAL	 CJNVE15100 P1161

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Job Number: 28259

Part Number: D2884

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 398

P. 4/9/2 (50)

8.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

(50) 06/09/07

Job Completion



U 06.09.07

Date: Monday, 8/21/2006 2:11:59 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER		
Job Number	28259	Part Number	: D2884		
Estimate Number	11055	Drawing Number	: D2884 REV B		
P.O. Number	:	Project Number	: N/A		
This Issue	8/21/2006	Type	: MACHINED PARTS		
Prsht Rev.	NC	Drawing Revision	: B		
First Issue	/ /	Material	:		
Previous Run	25982	Due Date	8/28/2006	Qty:	40 Um: Each
Written By	:				
Checked & Approved By	:				
Comment	: Est A 99.10.12 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6S080	6061-T6 .080 Sheet		
		Comment: Qty.: 0.0663 sf(s)/Unit Total : 2.6502 sf(s) Material: 6061-T6 0.080" Thick Batch _____		<i>Forget</i>
2.0	SHEAR	SHEAR		
		Comment: SHEAR 1 blank makes 4 parts Blank: 7.90" x 4.60" (+0.030" - 0.000")		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2884 2-Tumble 3-Deburr any rough edges after tumbling		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:11:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 28259

Part Number: D2884

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

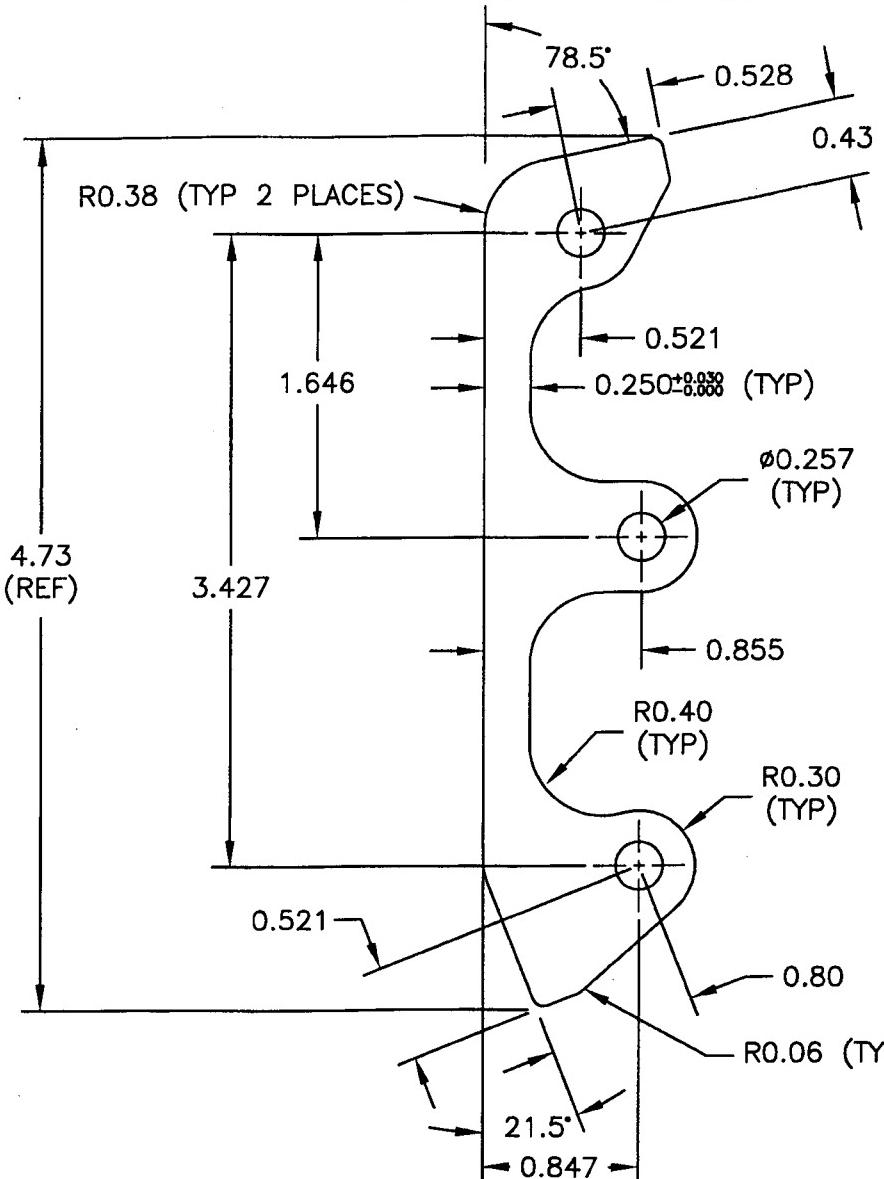
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2884	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080) OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK ENGINEERING
(REF DART SPEC M5052H32S.080)
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 5) ALL DIMENSIONS ARE IN INCHES
- SHOP COPY
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *28259*

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DART AEROSPACE LTD	Work Order:	28259
Description:	Part Number:	2884
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:	SAD	Audited by:		Prototype Approval:	
Date:	06.08.23	Date:	06.08.23	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	